

Date: Thursday, 28/05/2009 11:34:07 AM
 User: Julie Dawson

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : X-BOLT SPACER |
| Job Number : 48277 | |
| Estimate Number : 12321 | |
| P.O. Number : | Part Number : D34901 |
| This Issue : 28/05/2009 S.O. No. : | Drawing Number : D3490 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 11 Type : MACHINED PARTS | Drawing Revision : A |
| Previous Run : 47657 | Material : |
| Written By : | Due Date : 04/06/2009 Qty: 100 Um: Each |
| Checked & Approved By : <u>JUD 09.05.28</u> | |
| Comment : Est Rev:A New Issue 06-03-03 JLM | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|------------------|-----------------------------|
| 1.0 | M6061T6T0500W049 | 6061-T6 RD Tube .500 x.049W |
|-----|------------------|-----------------------------|



Comment: Qty.: 0.2793 f(s)/Unit Total: 27.9300 f(s)
 6061-T6 Tube .500 x.049W
 (M6061T6T0.500W.049)
 Batch: M111028

29.2 Pt

SA 09/06/03

| | | |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA628 & DWG D3490
 FOLIO REV: A
 DWG REV: A

2-DEBURR AS REQUIRED

SA 09/06/03

109

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/06/03

109

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

mk 09/06/03

109

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: Bulky

9/6/4

109

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 11:34:07 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 48277

Part Number: D34901

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/05 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

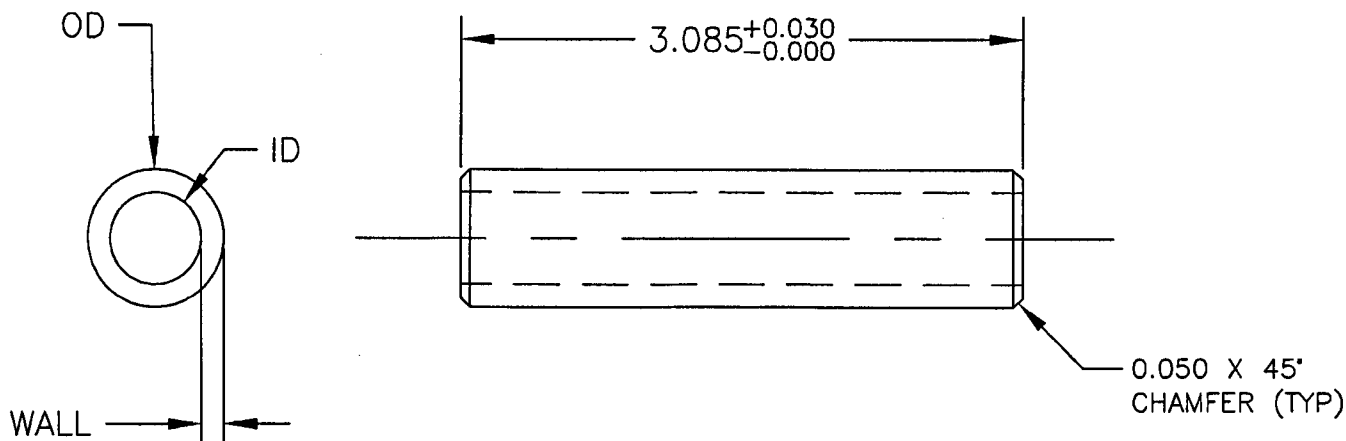
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>PH</i> | DRAWN BY <i>PH</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3490 | REV. A SHEET 1 OF 1 |
| DATE 06.01.04 | | TITLE CROSS BOLT SPACER | SCALE NTS |
| A | 06.01.04 | NEW ISSUE | |



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

| PART NUMBER | OD | WALL | ID (REF) | MATERIAL SPEC |
|-------------|-------|-------|----------|--------------------|
| D3490-1 | 0.500 | 0.049 | 0.402 | M6061T6T0.500W.049 |
| D3490-3 | 0.750 | 0.080 | 0.591 | M6061T6R0.750 |
| D3490-5 | 0.313 | 0.058 | 0.197 | M6061T6T0.313W.058 |

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. *14827*

RELEASED
06-02-07

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